

1504

# Work Order ID 69961

Wednesday, May 25, 2011 8:09:31 AM



Item ID: D206-642-312BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 5/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D206-642

N

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-312 CHG006

Substky

CL 11-7-6

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/7/7

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Substky

AD

B70939

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69961**

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Item ID: D206-642-312BL

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 5/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-312 Location: _____ PPP Rev: _____	<i>F</i>							
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*Packaging**QC21**mf**11-07-14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Picklist Print

Wednesday, May 25, 2011 8:09:37 AM

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Work Order ID: 69961

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC  
 IPP Rev: K 07-12-04 ECN 1080p DD verified by: ec  
 IPP Rev: L 08-09-29 as per DSI9421 DD verified by: EC IPP Rev: M  
 09-03-02 as per DSI9440 rev.a verified by: EC  
 IPP Rev: N 09-03-03 as per DSI9421 rev.b verified by: EC IPP Rev: O  
 as per REV.N DD 10.04.19 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-341 Replacement Skidtube		Manufactured	No			110	Each	3.0000	1	1			

Location	Loc Qty	Loc Code
FG082	3	
36550	1	
44043	1	
44044	1	

D206-648-013 GHW Modification		Manufactured	No			110	Each	10.0000	1	1			
----------------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
FG120	10	
67596	6	
68347	4	

ATTN: D3414-041 BLUE D2932-2 Saddle RH Out, 206		Manufactured	No			110	Each	5.0000	1	1			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST421	5	
66381	1	
67253	4	

BLUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 69961

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2933-2  
Saddle RH In, 206

Manufactured No

110 Each

4.0000

Location

Loc Qty

Loc Code

ST421

4

67254

4

BLUE  
D2938-2  
Saddle RH Out, 206

Manufactured No

110 Each

4.0000

Location

Loc Qty

Loc Code

ST421

4

67255

4

BLUE  
D2939-2  
Saddle RH In, 206

Manufactured No

110 Each

4.0000

Location

Loc Qty

Loc Code

ST421

4

67256

4

BLUE  
AN3-41A  
Bolt

Purchased No

110 Each

323.0000

Location

Loc Qty

Loc Code

ST354

323

112431

1

115936

72

116191

200

117794

50

Wednesday, May 25, 2011 8:09:38 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 69961

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2652 /  
Bushing

Manufactured No

110 Each

424.0000

16 16

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

380

67756

180

68941

200

MS21042L3 /  
Nut

Purchased No

110 Each

2,178.000

8

Location

Loc Qty

Loc Code

ST300

2178

116391

11

116540

201

116549

766

117441

800

117601

400

AN960JD10 NAS1149D0363J  
Washer

Purchased No

110 Each

0.0000

8

AN5-10A  
Bolt

Purchased No

110 Each

304.0000

4

Location

Loc Qty

Loc Code

ST337

304

117313

179

117795

125

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 69961

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-11A Purchased No 110 Each 92.0000  
Bolt

4 4  
116702

Location Loc Qty Loc Code

ST337 92  
117313 92

AN960JD516 NAS1149D0563J Purchased No 110 Each 0.0000  
Washer  
AN4-6A Purchased No 110 Each 1,099.000  
Bolt

8 8  
1116702

Location Loc Qty Loc Code

ST356 899  
115936 99  
116400 400  
116924 400  
ST358 200  
117514 200

AN960JD416 NAS1149D0463J Purchased No 110 Each 0.0000  
Washer  
MS21042L4 Purchased No 110 Each 4,682.000  
Nut

24 24  
1117460  
12 12  
11174

Location Loc Qty Loc Code

ST300 4682  
116823 882  
117441 3000  
117601 800

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, May 25, 2011 8:09:39 AM

Work Order ID: 69961

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110 Each

19.0000

1 1



Tow Ring



B69662 \$

Location

Loc Qty

Loc Code

ST420

2

66386

2

ST464

17

64071

7

68339

10

BLUE

D3456-1

Manufactured No

110 Each

71.0000

1 1



Washer



B71033 \$

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

64

63239

4

66848

6

68748

54

D3457-1

Manufactured No

110 Each

40.0000

2 2



Washer



B70774 11/7/78

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

30

67779

30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 69961

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4  
Nut

Purchased

No

110

Each

1,670.000

1

1

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

576

117423

576

ST301

1054

115936

40

116549

14

117601

500

117793

500

Purchased

No

110

Each

530.0000

1

1

Location

Loc Qty

Loc Code

FP-B

115

112243

115

ST345

415

112243

415

Purchased

No

110

Each

0.0000

1

1

AN960C416  
washer

NAS1149C0463  
R



M117735 11/7/7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Wednesday, May 25, 2011 8:09:39 AM

Page 7

Work Order ID: 69961

Parent Item: D206-642-312BL

Parent Item Name: Skidtube RH

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D3413-1

Manufactured No

110 Each

34.0000

1 1



Ring

Location

Loc Qty

Loc Code

ST420

19

62961

8

66387

11

ST473

15

65294

1

66945

14

BLUE

D2712

Manufactured No

110 Each

451.0000

10 10



Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST012

252

66955

252

ST021

149

65115

149

D2934

Manufactured No

110 Each

38.0000

2 2



Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

32

67585

32

Wednesday, May 25, 2011 8:09:39 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Wednesday, May 25, 2011 8:09:39 AM

Work Order ID: 69961



Parent Item: D206-642-312BL



Parent Item Name: Skidtube RH

Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 1.00

Required Qty: 1.00

D2935

Manufactured No

110

Each

56.0000

2

2



Saddle Spacer



11/7/78

Location

Loc Qty

Loc Code

ST027

56

66564

56

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 4.5 206 L/L-1/L-3/L-4/407 LOW &amp; HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG <sup>(1)</sup>
2B			14			D2651-3	* O-RING <sup>(1)</sup>
3			1			D2646	* AFT CAP <sup>(1)</sup>
4			2			MS27039-1-08	* SCREW <sup>(1)</sup>
5			2			AN960JD10L	* WASHER <sup>(1)</sup>
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT <sup>(2)</sup>
14	4	4				AN5-11A (OR AN5-12A)	* BOLT <sup>(2)</sup>
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT <sup>(1)</sup> (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: <sup>(1)</sup> DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE<sup>(2)</sup> CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Revision: N

Date: 09.09.09